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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9357	REV. B SHEET 1 OF 2
DATE 06.12.05		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS
A	06.10.25	NEW ISSUE	
B	06.12.05	D2732-058 & MS21920-32 WERE D2182B058 & MS21920-30;ADD DSI KIT	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-664 Rev. C AND
INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D212-664 Rev. 2
REF. CANADIAN STC: SH01-9
REF. FAA STC: SR01298NY

For D412-664-203 Aft Crosstubes at CHG 003 or later, the D2856-600-1087 Abrasion Strip has been removed, the center D2896-1 Support has been bonded onto the crosstubes using Magnobond 6398 and D2732-058 Rubber Cushions have been installed underneath the MS21920-32 Clamps. Amend Parts List of IIN-D212-664 Section 5 and ICA-D212-664 Section 32.8 as follows:

Remove:

Item	QTY -203	Part Number	Description
32	1	D2856-600-1087	ABRASION STRIP
34	2	MS21920-30	CLAMP

Add:

Item	QTY -203	Part Number	Description
34	2	MS21920-32	CLAMP
41	2	D2732-058	RUBBER CUSHION

To prevent the center support from shifting on D412-664-203 Crosstubes at CHG 001, the D2896-1 Support should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D212-664 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty(2) MS21920-30 Clamps from the crosstube that fasten the D2896-1 Supports to the crosstube.
- 3) Remove the D2856-600-1087 Abrasion Strip from the crosstube per section 32.5 of ICA-D212-664.
- 4) Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection.
- 5) Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2896-1 Support and re-install the Support on the crosstube as shown in Figure 1. Use rocker beam assembly to properly align the D2896-1 Support. Ensure the Rocker Beam Assembly can move freely without any friction with other parts. Install a D2732-058 Rubber Cushion on each MS21920-32 Clamp. Position and secure the D2896-1 Support on the crosstube using MS21920-32 Clamps. Torque clamps 80-100 in-lb. Let the D412-664-203 Crosstube Assembly cure before re-installing the crosstube on the aircraft.
- 6) Re-install the D412-664-203 crosstube per section 32.2.5 through 32.2.9 of ICA-D212-664.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.12.05
CERT. NO.: SH01-9
ISSUE: 3

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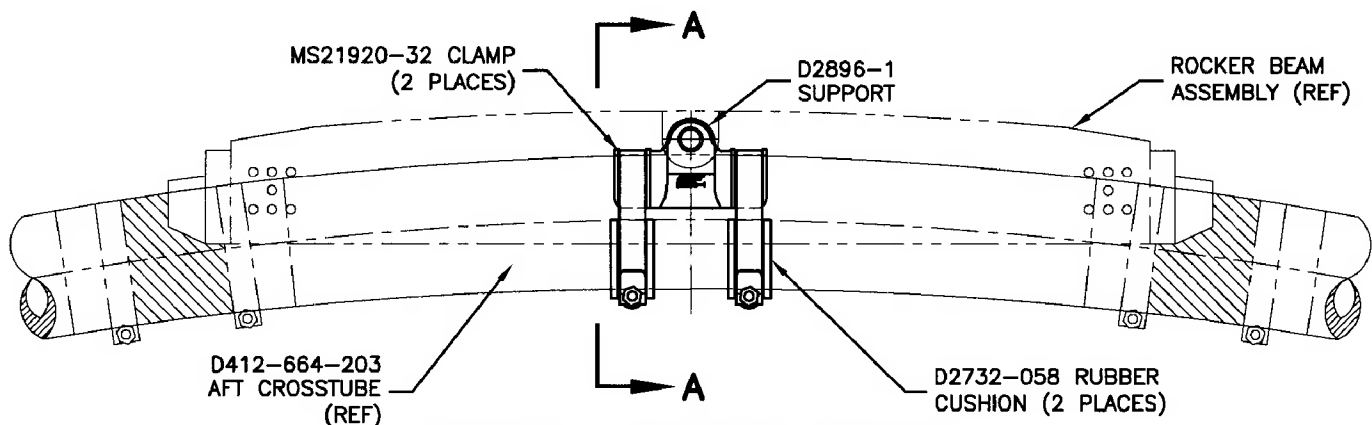
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9357	REV. B SHEET 2 OF 2
DATE 06.12.05	TITLE CROSSTUBE SUPPORT CHANGE		SCALE NTS

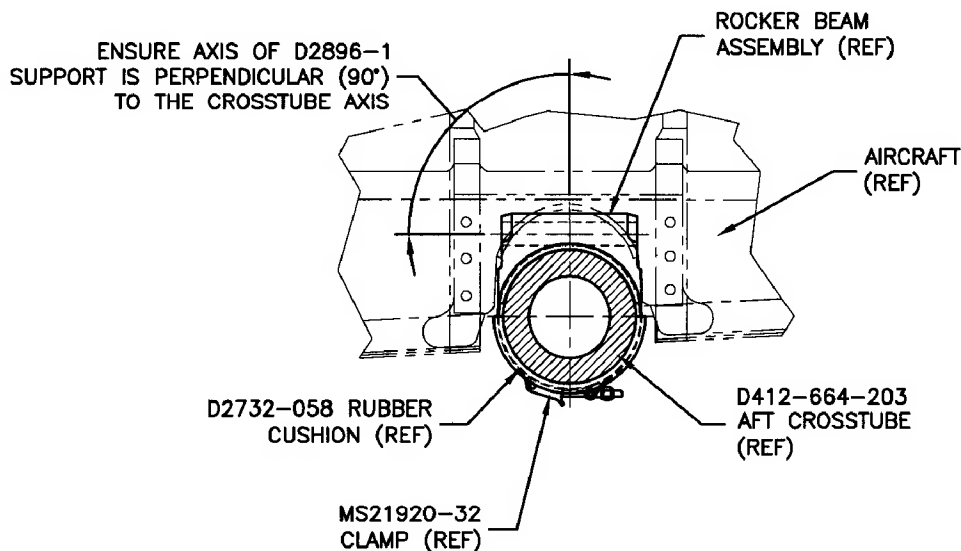
For customers who would like to upgrade their D412-664-203 Aft Crosstubes from CHG 001 or CHG 002 to CHG 003, the following kit can be obtained from Dart:

DSI 9357-011 PARTS LIST

QTY -011	Part Number	Description
X	DSI 9357-011	CROSSTUBE SUPPORT CHANGE
2	D2732-058	RUBBER CUSHION
2	MS21920-32	CLAMP



**FIGURE 1 - CROSSTUBE SUPPORT
INSTALLATION ON D412-664-203**



SECTION A-A
AIRCRAFT BODY SHOWN
AS REFERENCE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

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